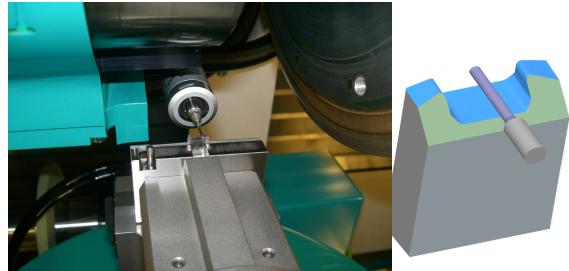


## Insert Profile Probing

### A8-010

To garant a precise continuity in production of series of high precision profiled inserts, probing of up to 6 profile keypoints can be used for autocorrection. A measurement point is defined in the station coordinatesystem and the measurement direction. The usage of the probed value can be redefined case by case, depending on the type of wheel and the correction necessity.

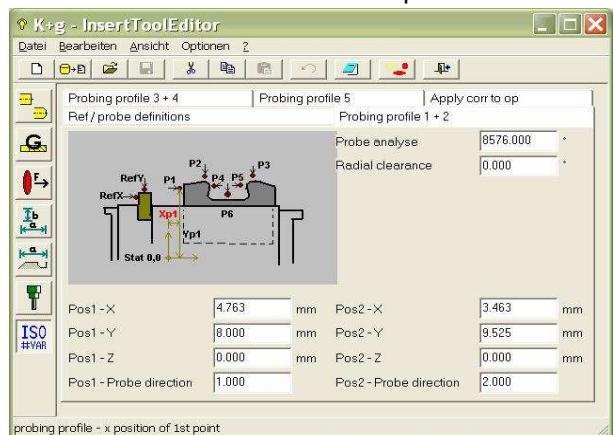


### 1. Cycletime for Production

Tool specifications BxH: 9.5x9.5   Material CARBIDE				
Operations	Probe side	Prof. Prgrd	Prof. Fin.	Prof. Probe
Feed [mm/Min]	2000	45	80	100
Power [kW]		1	1	1
Cutting feed [m/s]		24	24	24
Used wheels		23	22	
Grinding time [s]	11	77	49	21
Total cycle time	2 Min 38			

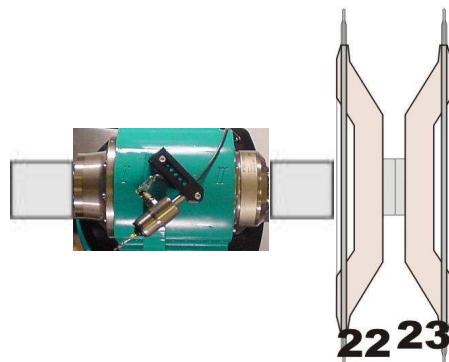
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

The definition of a measurement point in Quinto



### 2. Used Grinding Wheels

23 Ø300 14EE1 D64  
22 Ø300 14EE1 D46



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIR HPM, STL 650  
Control: Fanuc 160i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 4.3

responsible engineer: OP,5.11.07

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